

Date: Tuesday, 11/6/2007 3:42:45 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LABEL PLATE
Job Number : 35585	
Estimate Number : 10599	
P.O. Number : N/A	Part Number : D2506
This Issue : 11/6/2007 S.O. No. : N/A	Drawing Number : D2506 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 33449	Material : N/A
	Due Date : 11/23/2007
Written By : <u>JA 07 11 07</u>	Qty: 27 Um: Each
Checked & Approved By : <u>JA 07 11 07</u>	
Comment : Est. B 01.06.08 Now laser cut EC	
est C 06.12.13 ecn 822 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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34587



Comment: Qty.: 1.2810 sf(s)/Unit Total : 32.0250 sf(s)

304/316 .040 Sheet 223x 29.463

Batch: 105841 B 07-11-8

105871 4X = 5.124

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: E

Prog Rev: E

B 07-11-8

27

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 07-11-8



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



counters

Comment: SECOND CHECK

6 07/11/09

427

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

N/A 05-08-10-09

Done at step 2.2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/11/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 3:42:45 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 35585

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

JB 07/11/21 (27)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count
4 07/11/21 (+27)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 201

CP

JS 07/11/21

(27)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

(27)

Job Completion



U 07/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35585
Description: Label Plate		Part Number:	D2506
Inspection Dwg: D2506 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.63	+/-0.030	32.63	X			
39.00	+/-0.030	39.00	X			
4.50	+/-0.030	4.50	X			
1.31	+/-0.030	1.308	X			
1.88	+/-0.030	1.88	X			
0.040	+/-0.010	.041				

Measured by: HB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07-11-8	Date: 07/11/09	Date:	N/A

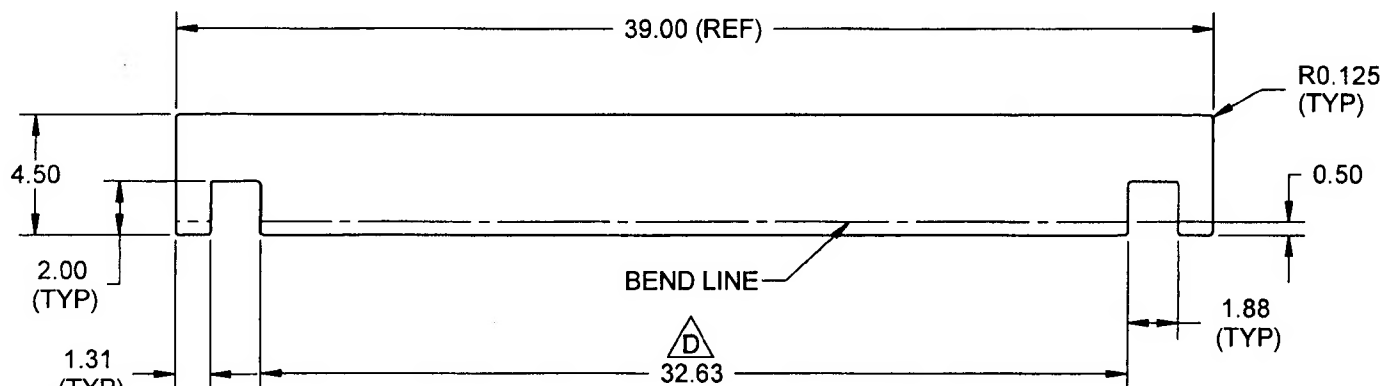
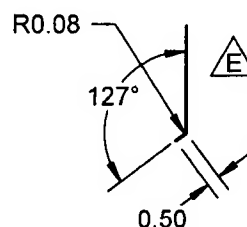
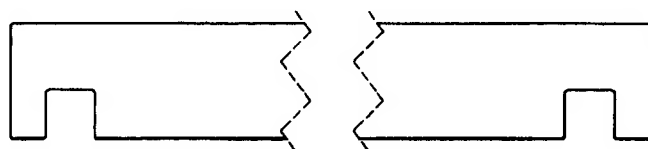
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	07.09.06	0.040 dimension added	KJ/JLM	[Signature]

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2506	REV. E SHEET 1 OF 1
DATE 06.11.20	TITLE LABEL PLATE SCALE 1:7		
REV	DATE	DESCRIPTION	
A	95.11.26	NEW ISSUE	
B	96.06.18	RE-DESIGN OF LABEL PLATE	
C	96.09.04	RE-DESIGN OF LABEL PLATE	
D	99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50	
E	06.11.20	REMOVE 10° BEND; ADD NOTES; 127° WAS 126°	

RELEASED

06.11.28

**D2506F FLAT PATTERN****D2506 LABEL PLATE**

E

NOTES:

- 1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019 (REF DART SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHUT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35585

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